

Date: Monday, 11/21/2005 1:17:56 PM
User: Linda Lacelle

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE |
| Job Number : 24856 | |
| Estimate Number : 10834 | |
| P.O. Number : N/A | Part Number : D29332 |
| This Issue : 11/21/2005 S.O. No. : N/A | Drawing Number : D2933 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : N/A | Material : N/A |
| Written By : SEE COMMENT BELOW | Due Date : 12/21/2005 Qty: 4 Um: Each |
| Checked & Approved By : SEE ABOVE USER & DATE | |
| Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------|---------------------|
| 1.0 | D6101001 | 7075-T7351 2X6X6.25 |
|-----|----------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: 24890

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
5-Deburr

J.L 06.04.21 (4)

| | | |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

J.L 06.04.21 (4)

| | | |
|-----|-----|------------------------------|
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

J.L 06.04.21 (4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 19 Date: 06/04/08
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 1:17:56 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 24856

Part Number: D29332

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

mk 06/04/21 4

| | | |
|-----|-----------------|----------------------------|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JAD 06:04:22 (4)

| | | |
|-----|----------------|----------------|
| 7.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/25 (4)

| | | |
|-----|-----|---|
| 8.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT

06/04/27 (4)

| | | |
|-----|-------------|-----------------------|
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST475

AL 06/04/27 (4)

| | | |
|------|----|------------------|
| 10.0 | DC | DOCUMENT CONTROL |
|------|----|------------------|



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/28 (4)

Job Completion



CL 06/04/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|---|--|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: 206 Saddle, Inboard, Right side | | Part Number: | D2933-2 |
| Inspection Dwg: D2933 Rev. B | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | .122 | .123 | .121 | .122 | | |
| B | 0.100 | 0.140 | | .123 | .123 | .123 | .123 | | |
| C | 0.100 | 0.140 | | .120 | .119 | .120 | .118 | | |
| D | 0.210 | 0.230 | | .221 | .221 | .220 | .222 | | |
| E | 1.245 | 1.255 | | 1.250 | 1.249 | 1.250 | 1.250 | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| G | 2.495 | 2.505 | | 2.499 | 2.500 | 2.500 | 2.500 | | |
| H | 0.510 | 0.515 | | .514 | .514 | .514 | .514 | | |
| I | 1.572 | 1.582 | | 1.576 | 1.576 | 1.577 | 1.577 | | |
| J | 2.495 | 2.505 | | 2.499 | 2.500 | 2.500 | 2.500 | | |
| K | 0.257 | 0.262 | DT8683 | | | | | | |
| L | 0.312 | 0.317 | DT8686 | | | | | | |
| M | 0.235 | 0.240 | | .239 | .240 | .240 | .239 | | |
| N | 0.100 | 0.140 | | .120 | .120 | .119 | .119 | | |
| O | 0.540 | 0.560 | | .550 | .549 | .550 | .550 | | |
| P | 0.490 | 0.510 | | .500 | .499 | .498 | .499 | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.719 | 3.719 | 3.720 | | |
| R | 2.470 | 2.510 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| S | 0.240 | 0.270 | | .247 | .251 | .250 | .251 | | |
| T | 0.100 | 0.180 | | .140 | .140 | .140 | .140 | | |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | 1.630 | 1.630 | | |
| V | 1.362 | 1.372 | | 1.367 | 1.367 | 1.367 | 1.367 | | |
| W | 0.316 | 0.321 | DT8690 | | | | | | |
| X | 1.125 | 1.145 | | 1.135 | 1.136 | 1.135 | 1.136 | | |
| Y | 1.565 | 1.585 | DT8695 A/B | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | J.L |
| Date: | 06-04-21 |

| | |
|-------------|----------|
| Audited by: | gml |
| Date: | 06/04/21 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF | |

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

| | | | |
|-------------------|--------------------|------------------------------|----------------|
| Work Order No | : 0024856 | Department Code: | |
| Project Name | : D2933-2 | Burden Flags | : NNNNNNNN |
| Project For | : WK551 | WO Status | : Open |
| Work Order Type | : Main | Invoice State | : Not Invoiced |
| Main WO Number | : | Invoice Date | : |
| House Part Number | : D2933-2 | Invoice Number | : |
| Description | : 206 Saddle Right | Invoice Amount | : 0.00 |
| Manufactured | : Yes | | |
| Amount Req'd | : 4 | Order Entry No | : |
| Amount Done | : 0 | OE Value | : 0.00 |
| Start Date | : 11-17-05 | | |
| Est Finish Date | : 12-21-05 | Est Margin | : 0.000% |
| Act Finish Date | : | Actual Margin | : 0.000% |
| Drawings Req'd | : No | | |
| Ok for Approval | : | | |
| Approval Rec'd | : | \$0 Posted to Finished Goods | |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | 0.00 | 0.00 | 0.00 | | |
| Production Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | 0.00 | 0.00 | 0.00 | | |
| CNC | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | 0.00 | 0.00 | 0.00 | | |
| Misc. | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | 0.00 | 0.00 | 0.00 | | |
| Total Cost | 0.00 | 0.00 | 0.00 | | |
| Margin | 0.000 | 0.000 | | | |
| Selling Cost | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | 0.00 | 0.00 |
| Profits/(Loss) | 0.00 | 0.00 |

Date: Friday, 4/28/2006 7:16:59 AM

User: Chantal Lavoie

**INVENTORY ITEMS PICKED
FOR SLIP NUMBER 2130**

| | | | |
|----------------------|---------------------------|-------------------------|---------------------------------------|
| Project No. : | | Drawing Number : | D2933 REV B |
| Customer : | Dart Helicopters Services | Drawing Name : | 206/OH-58 SADDLE, INBOARD, RIGHT SIDE |
| Part Number : | D29332 | Due Date : | / / |
| Job Number : | 24856 | Qty : | 4 |
| | | Slip # : | 2130 |

| | Location | Store | Picking | Lot No. | Serial No. | Req'd | Taken |
|---|----------|-------|---------|---------|------------|-------|-------------|
| 1.0 D6101001 7075-T7351 2X6X6.25 Available 245.00 | MAIN | | | 24890 | | 4.00 | 4.0000 Each |